Quality Control

Work Orde June-24-13 1:57		3536		*103536*											Page 1		
Item ID: Revision ID:	D3917-	3 ,,					Accept	-	*N90	004 0	1100	ገ*	Setup	Start	*N	S1*	
Item Name:	Washer													Stop	*N	S2*	
Start Date: Required Date: Reference:	6/19/13 7/05/13		Start Qty: Req'd Qty			*40* *40*			Cust Ite Custom								
Approvals:	Proces	e Plai	n· AA.	··_	Date:	12-12/0-7	∳ Tooling:	1, 1		Date:			Run	Start	*N	R1*	
Approvais.						15 00 1	1	<i>y</i> -		Date:				Stop	*N	R2*	
Sequence ID/ Work Center II	D		Operation Description				Set Up/ Run Hou		Tool I	D Tool	# Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	
Draw Nbr		Revi	ision Nbr														-
D3917		Α															
*100 *100* Hardinge Hardinge CNC Lath	ne Small		T F	OLIO RE	SPER FOLIO EV: <u>AA</u> V: <u>A</u>	FA876 & DW	0.00 0.00 //G	0	MH	(3/06/	17	4,	/	,			
•			Г	EBURR				T7	<i>l</i> /							·.	
110 *440*			QC2- Inspect	parts off	machine FAI/	FAIB	0.00	-	P/ MH	13/00	5/2-	7	•	E7			
QC			N	I emo			0.00					7/				44-79-79	

DQA:			Date:										
						WORK ORDER NON-	-C(ONFO	RMANCE / U	PDATE			A E R O S P A C E
QA Closed:			Date:							V	Vork Order u	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
						Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				Use-as-is		Therr	noforming	Finishing	_	re/Packaging	Other		
NCR No.				Suspected Unapproved			Large Fab	Composite		Supplier			
Root					Desci	ription of work order update		Initial	Act	tion	Sign &		
Cause	_ Da	ate	Step	Qty		or non-conformance	Ch	nief Eng		ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_												
Handling/Pre	\Box							*					
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training	_					,							
Transport													
Unapproved	<u></u>				<u> </u>								
1 41							FAI	ULT CA	regory				
Landii	ng Gear	J:				General		1		_	7	_	· -]
	Bend	ing re Not (C	A	_	Bend		1	rogram	<u> </u>	Outside Dim		Pressure/Forced
	Crac		concen		<u> </u>	BOM/Route	_	Grain		<u> </u>	Over/Under	⊢	Set-up
			/Dinnlo	Maua		Broken/Damage/Defect	\vdash	Hardwa			Part Incorre	 	Temperature/Cure
	Crimp/Kink/Ripple/Wave			vvave	\vdash	Burrs	_	1	on Incomplete/Ur	· —	Part Lost/Mi	ssing	Weld
	Cuffs Crushing					Contamination Countersink		i	ions Incomplete/L	Inclear	Part Moved	L	Wrong Stock Pulled
		Treat			\vdash	Cut Too Short	_	Mislabe	ned/off center	<u> -</u>	Positioned V		ا
		ection S	itrin in '	Tuhe	_	Drawing	_	Misread			Power Loss/	ourge	Other
		ks/Chat		TUDE	-	Drill Holes	\vdash	Off-set	ı				
	_	ing Seq			<u> </u>	Finish	-	1	Calibration				
		e/Twist		e	_	Fit/Function	\vdash	i	Sequence			580	
				-	i	,		Jucois	cquence				

Work Order June-24-13 1:57:48		536			Page 2							
Revision ID:	3917-3 asher				Accept	*N900	<u>0</u> 40	100)* s	etup Star Stoj	171	S1*
Start Date: 6/1 Required Date: 7/0 Reference:		Start Qty: 40.00 Req'd Qty: 40.00		*40* *40*		Cust Item Customer:						
Approvals: P		:			Tooling: _ SPC (Y/N):		Pate:		R	un Star Stop	17	R1*
Sequence ID/ Work Center ID	(Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC8- Inspect parts - seco	na cneck		0.00		·		# \			1 13-6-27
130 *13 0 *		Identify as per dwg & Sto	ock Location:	<u>57072</u>	0.00				4/V		N. h.O.	13-06-2
Packaging Packaging		Мето			0.00					<u></u>	7	
140 *1 4 0*		QC21- Final Inspection -	Work Order	Release	0.00					13	3/7/0	24)
QC Quality Control		Memo			0.00							

13-7-00

DQA:			Date:			-								
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPD		ork Order up	odate only F	AEROSPA	ICE
Morte Ond						DISPOSITION				AGAINST DE	·			
Work Orde	er:			_							1	_		_,
Daget N	vio.					Rework	Skid-tube Crosstube				Water Jet	Engineering	4 !	
raiti	Part No.			-	Scrap Use-as-is		Machining Small Fab Thermoforming Finishing			•	d. Eng. Coor.	Quality		
NCR f	Nο					Suspected Unapproved		men	· —	Finishing Composite	Rec/Stor	re/Packaging	Other	-
NCR No.			_	Juspected Oliappioved			carge rab C	omposite[1	Supplier		┙╽		
Root			,		Desci	ription of work order update	- 1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	QC Inspecto	or
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Offset/Setup													Ì	
Process						•								
Supplier						·								
Training														
Transport														
Unapproved														
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Landi	ng Ge	ar				General		_						
	В	ending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		entre No	t Concen	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	\Box c	acks				Broken/Damage/Defect *		Hardwa	ire		Part Incorred	t T	Temperature/Cur	re
		rimp/Kin	k/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unqu	alified	Part Lost/Mi	ssing	Weld	
	L]C	uffs				Contamination		Instruct	ions Incomplete/Uncl	ear	Part Moved		Wrong Stock Pull	ed
	c	rushing				Countersink		Misalig	ned/off center		Positioned W	-		ļ
	Щн	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other	
	∐ln	spection	Strip in	Tube		Drawing		Misread	t			_		
	Шм	larks/Ch	atter			Drill Holes		Off-set						
	Tt	urning Se	equence			Finish		Out of (Calibration					
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence					

June-24-13 1:57:47 PM

Work Order ID:

103536

Parent Item:

D3917-3

Parent Item Name:

Washer

Start Date: 6/19/13

Required Date: 7/05/13

Start Qty: 40.00

Required Qty: 40.00

Comments:

Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD 10.02.22 verified by:FC

IPP Rev:B as per dwg REV.A DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750 Delrin Round Bar 0.75"	-	Purchased	No :		,	100	f	105.6540	0.02	0.842104			
P Section 1				Location		Loc Oty	<u>Lo</u>	c Code					
Name of the Control o				MAT018		105.654							
•				116	5183	4.8							
				117	273	4.665							
				117	7322	0.94							
				121	783	27.49				-			
				124	1834	40						* 1	
				== 124	1957	27.759			-8	47 (11	1 B/C	をクラフ	

DQA:	Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT				AEROSPACE
QA Closed:			Date:					7		W	ork Order up	date only	1
Work Orde	er:					DISPOSITION			AG	GAINST DE	PARTMENT	PROCESS	
						Rework			Skid-tube Cros	sstube	1	Water Jet	Engineering
Part N	No.					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality
-	-			_	Use-as-is		Thermoforming Finishing			4	re/Packaging	Other	
~ NCR N	NCR No.				Suspected Unapproved			Large Fab Com	posite		Supplier		
Root				l I	Descr	ription of work order update	l l	Initial	Action		Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design	\Box			•									
Doc/Data	\Box	1					1						:
Equip/Tooling													
Handling/Pre	Н					·							
Material													
Operator	\vdash	.,											
Offset/Setup	\dashv												
Process	H												
Supplier Training	\vdash					.*							
Transport						•							
Unapproved													
	L					·	FAI	ULT CA	TEGORY		1		
Landi	ng Gear					General							
1	Ben	ding				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Cen	tre No	t Concer	ntric	\Box	BOM/Route		Grain	_		Over/Under	tolerance	Set-up
	Crad	cks				Broken/Damage/Defect		Hardwa	are		Part Incorred	et	Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspect	ion Incomplete/Unqualific	ed	Part Lost/Mi	ssing	Weld
	Cuff	fs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Cru	shing				Countersink		Misali	gned/off center		Positioned V		
	Hea	it Treat	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Insp	ection	Strip in	Tube		Drawing		Misrea	d				
	<u></u> Mar	rks/Cha	atter			Drill Holes		Off-set					
	$\overline{}$	-	equence		-	Finish		Out of	Calibration				
	Wave/Twist in Tube			e e		Fit/Function	1	lout of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	103536
Description: Washer	Part Number:	D3917-3
Inspection Dwg: D3917 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.65	+/-0.030	. 6USS	1		Caliper	MHOY
0.06	+0.000/-0.020	.060	1		Caliper	MH -04
Ø0.257	+0.006/-0.001	ะวร7	7		Caliper Caliper	MH-04
4						
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L.,	. /			
Measured by:	MH /ON	Audited by:	Prototype Approval:	N/A
Date:	13/06/27	Date: 13-6-27	Date:	N/A
Day Data	Change		Dovingel by	A - A - A

10.04.01 New Issue

